NAV27 TEFLON COATING (REPAIR OF BALL VALVES)

A 1	A. Does supplier have procedures for Teflon Coating? List procedures: List Contract requirements	___Yes ___No
	B. Do procedures meet environmental laws?	
	C. How does supplier ensure compliance to local Environmental laws?	___Yes ___No
Coating Spray Area		___Yes ___No
A 2	A. Supplier's Teflon Coating Spray Area enclosed or isolated? B.	___Yes ___No
	B. Supplier's Teflon Coating Spray Area exhausted? How?	___Yes ___No
	C. Are adequate controls in place to protect from contamination?	___Yes ___No
	D. Are adequate controls in place for Temperature, Humidity, and sources of contamination?	___Yes ___No
B	E. Adequate safety precautions established? (i.e., respirators, no smoking, no eating, washing of hands)	___Yes ___No
	F. Air supply for spray gun checked for moisture, oil, and hydrocarbons?	___Yes ___No
	G. Spray gun checked for cleanliness prior to use?	___Yes ___No
	H. Written Procedures for cleaning spray gun? Method used:	___Yes ___No

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B 2	J. What is the method to transport balls to spray area?	
B 2	K. What is the method to handle balls during transport?	
	L. Are balls protected from contamination? How?	___Yes ___No
Primer and Final Coat Material		
A 3	A. Are receipt inspections performed on Teflon coating material? List inspections performed: List primer used: List final coat used:	___Yes ___No
	B. Are inspections performed on primer and final prior touse? (Temperature, shelf life, separation) List others:	___Yes ___No
	C. Are inspections documented? Batch Numbers recorded?	___Yes ___No
	D. Primer and final coat strained prior to use? List methods:	___Yes ___No

	E. Storage requirements addressed? List method?	___Yes ___No
Ovens		
A 4	A. Type of Curing oven?	
	B. Type of oxidizing oven?	
	C. Written procedures for calibrating ovens? Method: Intervals: Last calibration date:	___Yes ___No
	D. Are ovens exhausted? Method:	___Yes ___No
Inspection and Prep of balls for Teflon coating (Ball repair only)		
A5	A. Procedure for cleaning balls in the as-received condition? List:	___Yes ___No
A 5	B. Document acceptance procedure to determine acceptance for repair?	___Yes ___No
	C. Are dimensions verified?	___Yes ___No

	D. Surface condition inspected?	___Yes ___No
	E. Generic tests performed to identify material?	___Yes ___No
	F. Results of inspections documented?	___Yes ___No
	G. Welding repair performed? List procedures:	___Yes ___No
	H. Additional Machining required to clean ball? List operations: List cutting fluids: List method for obtaining 16 RHR finish (prior to oxidizing):	___Yes ___No
	J. Cutting fluids or lubricant source of oil or hydrocarbons?	___Yes ___No
	K. Is ball inspected after machining or welding (dimensions porosity, surface finish) and documented? List others:	___Yes ___No
Cleaning after final machining/welding		
A 6	A. Are solvents used to clean balls? List solvents used:	___Yes ___No
	B. Solvents used a source of hydrocarbons? (If yes, note for question 6E.)	___Yes ___No
	C. Ball dried before final cleaning? List procedure:	___Yes ___No
	C. Ball protected from contamination during drying?	___Yes ___No

	E. Ball inspected for residual oils/hydrocarbons after cleaning/drying?	___Yes ___No
Oxidizing of Ball Surfaces		
A 7	A. Specified time between drying and Oxidizing? B.	___Yes ___No
	C. Specified temperature for Oxidizing?	___Yes ___No
	C. Specified method to verify Oxidation?	___Yes ___No
	D. Specified method to cool ball?	___Yes ___No
	E. Ball protected from contamination during cooling?	___Yes ___No
Final Surface Preparation prior to Teflon coating		
A 8	A. List elapsed time between oxidation and final surface preparation:	
	B. Method use to obtain 32 RHR surface preparation (After Oxidizing):	
	C. Method use for grit blasting:	
	D. Does grit blasting remove the oxide coating?	___Yes ___No
	E. Grit blasting equipment checked for sources of moisture, oil or hydrocarbons?	___Yes ___No
	F. Method used to clean ball after grit blasting: List any solvents:	
	G. Method use to dry ball after cleaning:	
	H. Ball inspected for residual oils/hydrocarbons after cleaning and drying? Before After	___Yes ___No

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	J. Ball inspected for dimensions, before or after cleaning?	___Before ___After
	K. Ball inspected for porosity, before or after cleaning?	___Yes ___No
	L. Ball inspected for surface finish, before or after cleaning?	___Yes ___No
	M. Ball inspected for other inspections, before/after cleaning? List inspections:	___Yes ___No
	N. Inspections documented?	___Yes ___No
	O. How is ball handled and protected from contamination during inspection, cleaning and drying: Procedure used for applying prime coating	
A 9	A. Elapsed time between final surface preparation and application of primer coat:	
	B. Number of final coats:	
	C. Thickness of coats:	
	D. Elapsed time between coats:	
	E. Inspection for continuous and discontinuous coat	___Yes ___No
	F. Method of drying primer coat:	
	G. Method used to protect material from contamination during drying:	
	H. Is spray gun cleaned after primer coat?	___Yes ___No

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Fusing/curing of primer coat		
A 10	A. Elapsed time between spray coating and curing:	
	B. Is material protected from contamination in transporting to ovens?	___Yes ___No
	C. Oven temperature settings:	
	D. Method used to determine when primer is cured:	
	E. Temperatures and times in oven recorded?	___Yes ___No
	F. Method used to cool ball after curing:	
	G. Ball cleaned after cooling?	___Yes ___No
	H. Primer coat inspected after cooling (Visual, Thickness, Adhesion, or other)	___Yes ___No
	J. Inspections documented?	___Yes ___No
	K. Material protected from contamination while staging for final Teflon coating? Procedure used for applying final Teflon coating	___Yes ___No
A 11	A. Elapsed time between primer and final application:	
	B. Number of final coats:	
	C. Thickness of coats:	
	D. Elapsed time between coats:	
	E. Inspection for proper final coat application?	___Yes ___No

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	F. Method of drying final coat:	
	G. Method used to protect material from contamination during drying:	
	H. Is spray gun cleaned after final Teflon coat? Fusing/curing of final Teflon coat	___Yes ___No
A 12	A. Elapsed time between spray coating and curing:	
	B. Is material protected from contamination in transporting to ovens?	___Yes ___No
	C. Oven temperature settings:	
	D. Method used to determine when final Teflon is cured:	
	E. Temperatures and times in oven recorded?	___Yes ___No
	F. Method used to cool ball after curing:	
	G. Ball cleaned after cooling?	___Yes ___No
	H. Final coat inspected after cooling (Visual, Thickness, Adhesion, or other)	___Yes ___No
	J. Inspections documented (i.e., adhesion test)?	___Yes ___No
	K. Explain how final Teflon coating inspections are documented.	

Additional Comments/Concerns: